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646.3301

Job Sheet 198470



Part No: 646.3301

Job Qty: 4 pcs

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/30/19

Job Tracking No:

Due Date: 8/9/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG 646.3300 REV NC3 IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.07 AS PER
DWG NC3 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Klt	4 pcs		8/9/19	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

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					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
120	Small Fab - 2 - B4B	4 pcs	8/9/19	0.00 5.56	Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
					Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
130	QC 5	4 pcs	8/9/19	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
140	Packaging 3-1 - Stock - B4B	4 pcs	8/9/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	

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				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
150	QC 21 - SA	4 pcs	8/9/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 110 - Pick Kit

Descriptions: **120** - Small Fab - TWO fastener must be install finger-tight (see note 9) Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7. exp. date: 12/20 3173 363

130 - QC5- Inspect part completeness to step on W/O

140 - Identify as per dwg & Stock Location: ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

150 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3310	LH Half - Upper Cutter Assembly <u>CK022</u>	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	8201710
646.3311	RH Half - Upper Cutter Assembly <u>CK022</u>	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	8202297
646.3312	Center Plate <u>CK015A</u>	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	826703
646.3313	Upper Guide <u>CK102</u>	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	3x 8167065-1x 8129763
646.3314	Blade <u>CK102</u>	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	8143288
646.3315	Blade <u>CK102</u>	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	8190730
646.3316	Blade <u>CK102</u>	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	8192284
AN3-12A	Bolt <u>ST349</u>	8 Ea (2 ea)	110-Packaging 1 - Pick Kit	8166926
AN3-14A	Bolt <u>ST349</u>	4 Ea (1 ea)	110-Packaging 1 - Pick Kit	8112900
MS21042L08	Nut <u>ST303</u>	72 Ea (18 ea)	110-Packaging 1 - Pick Kit	8205000
MS21042L3	Nut <u>ST303</u>	12 Ea (3 ea)	110-Packaging 1 - Pick Kit	8201983
MS27039-08-19	Screw <u>GA015</u>	72 Ea (18 ea)	110-Packaging 1 - Pick Kit	8201996
NAS1149F0332P	Washer (AN960-10L) <u>ST262</u>	24 Ea (6 ea)	110-Packaging 1 - Pick Kit	8167104
NAS1149FN832P	Washer (AN960-8) <u>ST263</u>	144 Ea (36 ea)	110-Packaging 1 - Pick Kit	8191300

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.3310	4	2	0
	646.3311	4	2	0
	646.3312	4	22	0
	646.3313	4	19	0
	646.3314	4	31	0
	646.3315	4	33	0
	646.3316	4	34	0
	AN3-12A	8	204	0
	AN3-14A	4	206	0
	MS21042L08	72	643	0
	MS21042L3	12	894	0
	MS27039-08-19	72	451	0
	NAS1149F0332P	24	2,296	0
	NAS1149FN832P	144	1,764	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

NCR NO.		Job: _____		DISPOSITION						DEPARTMENT/PROCESS							
Part No. _____				Rework Scrap Use-as-is		Skid-tube Machining Large Fab		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging		Engineering Water Jet Supplier Quality					
Date :		Sequence #:		QTY Affected :		MRB (QS1042)											
Description Work Order Deviation				Disposition													
				Completed By													
				Lead hand / Supervisor													
				QC / QA Coordinator													
Root Cause				FAULT CATEGORY													
Operator				Pressure/Forced		Contamination		Power Loss/Surge		Positioned Wrong							
Manufacturing Process				Bending		Misaligned/off center		Folio/Program		Outside Tolerance							
Equip/Tooling				Crushing		BOM/Route		Grain Direction		Drawing							
Handling/Preservation				Cracks		Broken/Damage/Defect		Weld		Finish							
Material				Crimp/Kink/Ripple/Wave/Twist		Incomplete/Unclear Instructions		Wrong Stock Pulled		Part Lost/Missing							
Product Improvement				Marks/Chatter		Drill Holes		Out of Sequence		Misread							
Process Improvement				Mislabeled		Fit/Function		Off-set/Set-up									
Human Factors				Other/Details:													